

Work Order ID 116194

Tuesday, April 08, 2014 10:14:29 AM

116194

Page 1

Item ID: D412-711-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Vertical Reference Door Modification LH

Stop ***NS2***

Start Date: 4/8/2014 Start Qty: 1.00 ***1***

Required Date: 4/8/2014 Req'd Qty: 1.00 ***1***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF Date: 14-4-8 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-711	H J M

100 Document Control **JB** 0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefiles and create labels per PPP D412-711-021 CHG001

DAS
31
9-89

14-04-15

120 Pick Kit 0.00

120

Packaging

Purchasing

Memo

0.00

Packaging

DAS
33
9-89

14-04-09

130 QC4- 100% Inspect kits for completeness 0.00

130

QC

Memo

0.00

Quality Control

DAS
31
9-89

14-04-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Work Order ID 116194

Tuesday, April 08, 2014 10:14:30 AM

116194

Page 2

Item ID: D412-711-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/8/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-711-021								
	Location: _____								
	PPP rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

1 14-04-15 8
32

ML5 14-04-15

① 14-04-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, April 08, 2014 10:14:26 AM

Page 1

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-761-043		Manufactured	No			120	Each	2.0000	1	1			
D412-761-043									**				DAS 06 9-89
Latch Mechanism													

DAS
31
9-89

Location	Loc Qty	Loc Code
FG030	2	
110320	2	

D412-711-101

Manufactured No

120 Each 2.0000

D412-711-101

Replacement Vertical Reference Window

DAS
31
9-89

Location	Loc Qty	Loc Code
FG090	2	
113530	1	
113740	1	

D3802-1-120

Manufactured No

120 Each 0.0000

D3802-1-120

Window Seal 3120"

D4165-1 9-89

Manufactured No

120 Each 2.0000

D4165-1

Doubler

DAS
31
9-89

Location	Loc Qty	Loc Code
ST206	2	
106396	2	

****** 114190 DAS 33 9-89

****** 115110 DAS 28 9-89

14-04-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, April 08, 2014 10:14:27 AM

Page 2

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

D4165-3 Manufactured No

120 Each

5.0000

1 1

DAS
33
9-89

D4165-3

Inner Door Panel

DAS
31
9-89

Location

Loc Qty

Loc Code

ST205

3

106408

3

ST206

2

109159

2

D4165-5 Manufactured No

120 Each

5.0000

1 1

DAS
33
9-89

D4165-5

Aft Rib

DAS
31
9-89

Location

Loc Qty

Loc Code

ST206

5

106421

2

109160

3

D4165-7 Manufactured No

120 Each

2.0000

1 1

DAS
33
9-89

D4165-7

Fwd Rib

DAS
31
9-89

Location

Loc Qty

Loc Code

ST206

2

106373

2

D4165-9 Manufactured No

120 Each

1.0000

1 1

DAS
33
9-89

D4165-9

Angle

DAS
31
9-89

Location

Loc Qty

Loc Code

ST206

1

109570

1

Tuesday, April 08, 2014 10:14:27 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, April 08, 2014 10:14:27 AM

Page 3

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

D4165-11
D4165-11
Door Cover Panel

Manufactured No

120 Each

8.0000



1

**

DAS
33
9-89



DAS
06
9-89

Location

Loc Qty

Loc Code

ST206

8

106344

8

120 Each

1.0000



1

**

DAS
28
9-89



DAS
06
9-89

D4207-1
D4207-1
Window Retainer

Manufactured No

DAS
31
9-89

Location

Loc Qty

Loc Code

ST206

1

106392

1

120 Each

4.0000



1

**

DAS
33
9-89



DAS
06
9-89

D4207-3
D4207-3
Instrument Window

Manufactured No

DAS
31
9-89

Location

Loc Qty

Loc Code

ST206

4

101815

2

106327

2

120 Each

8.0000



1

**

DAS
33
9-89



DAS
06
14-04-09

D4269-1
D4269-1
Angle

Manufactured No

DAS
31
9-89

Location

Loc Qty

Loc Code

ST098

8

113505

4

114199

4



1

113505

Tuesday, April 08, 2014 10:14:27 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 4

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

D4269-3 Manufactured No

120 Each

5.0000

1 1

D4269-3

Angle

**

DAS

33

9-89

DAS

31

9-89

D4269-5

Manufactured No

120 Each

4.0000

1 1

D4269-5

Angle

**

Location

Loc Qty

Loc Code

ST098

5

109569

5

Location

Loc Qty

Loc Code

ST206

4

113504

4

D4269-7

Manufactured No

120 Each

0.0000

1 1

D4269-7

Angle

**

DAS

28

9-89

D4324-041

Manufactured No

120 Each

3.0000

1 1

D4324-041

Armrest Assembly

**

DAS

33

9-89

DAS

31

9-89

D4324-043

Manufactured No

120 Each

1.0000

1 1

D4324-043

Arm Support Assembly

**

DAS

28

9-89

Location

Loc Qty

Loc Code

ST103

1

113506

1

DAS

31

9-89

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Page 4

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, April 08, 2014 10:14:27 AM

Page 5

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

D4327-1

Manufactured No

120

Each

1.0000

1

D4327-1

Angle

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST206

1

79133

1

D4327-3

Manufactured No

120

Each

4.0000

1

D4327-3

Angle

**

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST204A

4

113509

4

D4385-1

Manufactured No

120

Each

6.0000

2

D4385-1

Placard

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST104

6

106367

4

84641

2

AN3-3A

Purchased No

120

Each

429.0000

22

22

AN3-3A

Bolt

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST350

429

m126249

1

m127815

178

m128429

250

127815

Tuesday, April 08, 2014 10:14:28 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, April 08, 2014 10:14:28 AM

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

AN3-4A

Purchased

No

120

Each

510.0000

20

20

AN3-4A

Bolt

**

DAS
33
9-89

DAS
06
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST350

462

m128429

100

m128634

62

m128739

300

ST511

48

m127044

48

128634

AN3-6A

Purchased

No

120

Each

370.0000

26

26

AN3-6A

Bolt

**

DAS
33
9-89

DAS
06
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST351

366

M128403

216

M128739

150

ST511

4

M127044

4

128403

AN3-12A

Purchased

No

120

Each

112.0000

1

1

AN3-12A

Bolt

**

DAS
33
9-89

DAS
06
9-89

12-64-09

DAS
31
9-89

Location

Loc Qty

Loc Code

ST351

88

m128398

38

m128687

50

ST511

24

m125709

24

125709

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 7

Tuesday, April 08, 2014 10:14:28 AM

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

120

Each

7,206.000

92

92

NAS1149F0332P

Washer

**

DAS
33
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

205

122063

205

ST295

2558

123900

12

m123185

46

m128401

2500

ST510a

4397

125646

1897

m127831

2500

125646

ST522

46

m123185

46

CR3242-4-2

Purchased

No

120

Each

152.0000

34

34

CR3242-4-2

RIVET

**

DAS
33
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST329

152

117423

52

m127304

100

117423

MS20426AD3-3

Purchased

No

120

Each

7,568.000

135

135

MS20426AD3-3

RIVET

**

DAS
33
9-89

14-04-09

DAS
06
9-89

Location

Loc Qty

Loc Code

ST334

1162

123352

1162

ST553

6406

M128754

6406

123352

Tuesday, April 08, 2014 10:14:28 AM

Shop Packet Print

Pa

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, April 08, 2014 10:14:28 AM

Page 8

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-3

Purchased

No

120

Each

4,807.000

140

140

MS20426AD4-3

Rivet

DAS
31
9-89

Location

Loc Qty

Loc Code

GA

1807

113064

1807

ST334

3000

m125807

3000

**

DAS
33
9-89

MS20470AD3-3

Purchased

No

120

Each

7,076.000

25

25

MS20470AD3-3

RIVET, UNIVERSAL HEAD

DAS
31
9-89

Location

Loc Qty

Loc Code

GA

697

1065

697

ST335

6379

16941

6379

**

DAS
33
9-89

MS20470AD4-3

Purchased

No

120

Each

5,399.000

90

90

MS20470AD4-3

Rivet - Universal Head

DAS
31
9-89

Location

Loc Qty

Loc Code

GA

1516

1642

73

2193

1443

ST335

3883

2193

3883

**

DAS
33
9-89

14-04-09

Tuesday, April 08, 2014 10:14:28 AM

Shop Packet Print

Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, April 08, 2014 10:14:28 AM

Page 9

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

8,954.000

24 24

MS21042L3

Nut

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST314

1999

M127410

958

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

MS21059L3

Purchased

No

120

Each

342.0000

4 4

MS21059L3

Nut Plate

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST315

336

114449

4

114456

12

M127916

20

M128300

200

M128635

100

ST316

6

M127743

6

MS21069L3

Purchased

No

120

Each

130.0000

34 34

MS21069L3

ANCHOR NUT

**

DAS

33

9-89

14-04-09

DAS

31

9-89

Location

Loc Qty

Loc Code

ST317

130

m127813

2

m128429

28

m128650

100

28428429
6X128650

Tuesday, April 08, 2014 10:14:29 AM

Shop Packet Print

Page 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 10

Tuesday, April 08, 2014 10:14:29 AM

Work Order ID: 116194

116194

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/8/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

MS21069L08

Purchased

No

120

Each

1,867.000

8 8

DAS
33
9-89

MS21069L08

ANCHOR NUT

DAS
31
9-89

Location

Loc Qty

Loc Code

ST317

1867

123522

1867

242.0000

3 3

DAS
33
9-89

MS21071L3

Purchased

No

120

Each

242.0000

3 3

MS21071L3

ANCHOR NUT

Location

Loc Qty

Loc Code

ST317

242

114348

50

123185

8

123301

34

124291

50

125654

100

257.0000

1 1

DAS
33
9-89

MS21071L08

Purchased

No

120

Each

257.0000

1 1

MS21071L08

ANCHOR NUT

DAS
31
9-89

Location

Loc Qty

Loc Code

ST318

257

102587

157

103447

100

DAS
33
9-89

Shop Packet Print

Tuesday, April 08, 2014 10:14:29 AM

Page 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

REFERENCE ONLY

DAS
31
9-02

14-04-15

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
1	1	1	1	1	X			D412-711-021	VERTICAL REFERENCE DOOR KIT
						X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		* D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		** D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469 -14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		* D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		** D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		** D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		** D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		*** D4324-041	ARM REST ASSEMBLY
					1	1		*** D4324-043	ARM SUPPORT ASSEMBLY
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY
** PART OF EA20469-12 FWD RIB ASSEMBLY
*** PART OF EA20469-16 ARM REST ASSEMBLY

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. J
MFG. APPR.	N/A	D412-711	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL REFERENCE DOOR NTS	
DATE	14.03.25	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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REFERENCE ONLY

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149E0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
A ₁	A ₁	A ₁	A ₁	A ₁		1	204-030-853-119	LH COPILOT DOOR
1							D412-711-111	WIRING HARNESS, 212/412
B ₁							B _D 4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	B ₁						B _D 4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		B ₁					B _E A20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			B ₁				B _E A20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				B ₁			B _D 4268-047	INSTRUMENT PANEL, EAGLE SINGLE

(A) CUSTOMER SUPPLIED

(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

NOTES

1) WIRING HARNESSES:

For Bell 204/205/210/214 Wiring Harnesses, use drawing D2046904.

For Bell 212 Wiring Harnesses, use drawing D2046903*.

For Bell 412 Wiring Harnesses, use drawing D412-711-901.

For Bell 212 modified per SH07-28/SR02831NY use D212-761-224 or D212-761-225 depending on aircraft s/n.

* Despite the note on the drawing, D2046903 is applicable to all 212 aircraft serial numbers

Wiring Harnesses will vary depending on aircraft s/n.

2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

4) It is acceptable to use MS21042L3 nuts to install the window in lieu of anchor nuts shown on D2046901.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. J
MFG. APPR.	N/A	D412-711	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL REFERENCE DOOR	NTS
DATE	14.03.25	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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Work Order ID 116194

Tuesday, April 08, 2014 10:14:29 AM

116194

Page 1

Item ID: D412-711-021 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Vertical Reference Door Modification LH
 Start Date: 4/8/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/8/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Ship 15 April

Approvals: Process Plan: MF Date: 14-4-8 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D412-711	H	<i>JB</i>

100 Document Control 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefiles and create labels per PPP D412-711-021 CHG001

ML5 14-04-09

120 Pick Kit 0.00
120 Purchasing
 Packaging * Memo 0.00
 Packaging

130 QC4- 100% Inspect kits for completeness 0.00
130
 QC Memo 0.00
 Quality Control

Linda Lacelle

From: Melanie Fauteux
Sent: April-09-14 8:56 AM
To: Linda Lacelle
Cc: Eric Downing
Subject: RE: 711 VR door parts

Done.
I gave the work orders to Sylvain

Melanie

From: Linda Lacelle
Sent: Wednesday, April 09, 2014 8:11 AM
To: Eric Downing; Melanie Fauteux
Cc: Patrick Smith; Nigel Forbes
Subject: RE: 711 VR door parts

Cool, thx...
Mel, can you please get the parts out of quar. And make a w/o to scrap..
Thx
L

Sent: April-09-14 8:09 AM
To: Linda Lacelle; Melanie Fauteux
Cc: Patrick Smith; Nigel Forbes
Subject: RE: 711 VR door parts

Linda

Marc sent you the Batch numbers that were affected on Monday and he sent you the NCR about the issue. I don't know if the parts have been pulled from inventory on the system but I have them in quarantine that are defected.

From: Marc Bellavance
Sent: April-07-14 3:51 PM
To: Eric Downing; Harvey Siemens
Cc: Linda Lacelle; Nigel Forbes; Patrick Smith
Subject: RE: 711 VR door parts

All!

Per EricD:

No stock of D4269-7.

D4269-5 is to drawing. B113504

D4327-3 is not to drawing, scraping parts. B113509

Marc

Hope this helps
Downing

From: Linda Lacelle
Sent: Wednesday, April 09, 2014 7:40 AM
To: Eric Downing
Cc: Melanie Fauteux
Subject: RE: 711 VR door parts
Importance: High

Hi,
Have parts been removed from stk? Can we make w/o's to scrap pls, so this doesn't show in stk...
L

From: Linda Lacelle
Sent: April-07-14 4:08 PM
To: Marc Bellavance; Eric Downing
Subject: Re: 711 VR door parts

Pls ensure we get the parts to scrap on a wo.

Sent from my iPhone

On 2014-04-07, at 3:53 PM, "Marc Bellavance" <mbellavance@dartaero.com> wrote:

All,

Per EricD:

- No stock of D4269-7.
- D4269-5 is to drawing.
- D4327-3 is not to drawing; scraping parts.

Marc

From: Marc Bellavance.
Sent: April-07-14 3:33 PM
To: Eric Downing; Harvey Siemens
Cc: Linda Lacelle; Nigel Forbes; Patrick Smith
Subject: FW: 711 VR door parts

Harvey – Thanks; looking forward to receiving this batch number.

Eric – As discussed, please verify stock as per NCR14-3709.

Marc

From: Harvey Siemens
Sent: April-07-14 3:33 PM
To: Marc Bellavance
Subject: 711 VR door parts

Marc

Here are the batch numbers of the parts:

- D4327-3 B79145
- D4269-5 B79131
- D4269-7 B79146

Colin is getting me the batch number of the kit they came out of. He doesn't need a PO to bring them in, he will be happy getting the parts directly from me, so if you send them to me directly I will deliver. He will not be working on these doors in the very near future so we have a week or two to get him the parts that he needs.

Hope that works for you,